

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017557**Date Inspected:** 11-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yu Dong Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 27,28, located on Pad eye of Façade plate, Lift 3 –WD1-SFSA3-33. Welder is identified as 053829. ZPMC Quality Control Inspector (QC) is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112-Padeye.

Weld joint # 7, 8 - located on Pad eye of Façade plate, Lift 3 –ND1-SFSA3-44. Welder is identified as 053829. ZPMC Quality Control Inspector (QC) is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112-Padeye.

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

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ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 040, 41, located on Bike Path BK007A4- 001. Welder is identified as 057239. ZPMC Quality Control Inspector (QC) is identified as Sun Tiang Liang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 066, 067, located on Bike Path BK007A4- 001. Welder is identified as 057186. ZPMC Quality Control Inspector (QC) is identified as Sun Tiang Liang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 25, 26- located on Bike Path BK004A3- 031. Welder is identified as 053869, 052075. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T - 2132.

Weld joint # 51, 52, located on Bike Path BK004A6- 031. Welder is identified as 057180, 040302. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 13, 14- located on Bike Path BK004A6- 031. Welder is identified as 053869, 052075. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Bay #11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 023- located on Bike path component BK 004A8-018. Welder is identified as 040759. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 035, located on Bike path component BK 004A8-018. Welder is identified as 040704. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 006, 004- located on Bike path component BK 004A-018. Welder is identified as 040655. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared

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to comply with the WPS – B – P – 2114.

Weld joint # 216, located on Bike path component BK 004A7-027. Welder is identified as 040268. ZPMC Quality Control Inspector (QC) is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 168, located on Bike path component BK 004A7-027. Welder is identified as 056369. ZPMC Quality Control Inspector (QC) is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Bay #12

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006920

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG U Rib Splice plates. The weld designation reviewed as follows:

SA3114A- 004 – Jt. nos. -001, 002

SA3114A- 007 – Jt. nos. -001, 002

SA3114A- 014 – Jt. nos. -001, 002

SA3114A- 020 – Jt. nos. -001, 002

SA3114A- 026 – Jt. nos. -001, 002

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
